Work Order ID 70772

Wednesday, June 15, 2011 9:08:48 AM

Item ID: D2934 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Saddle Spacer

Start Date: 6/15/2011 **Start Qty:** 40.00 **Cust Item ID:**

Required Date: 6/22/2011 **Req'd Qty:** 40.00 **Customer:**

Reference:

Approvals: **Process Plan:** X **Date:** 11/06/15 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2934	Rev B								
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00				TB11-6-29			
FLOW CNC Waterjet	1-Cut as per Dwg D2934 ☐Dwg Rev: B ☐Prog Rev: B ☐2-								
6061 . 080	Deburr if necessary					49			
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				TB11-6-29			
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control									

11/07/06

Subc 6/30

counted x49

Work Order ID 70772

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish						49	ϕ	BR	11-7-6
Hand Finishing	**Memo**	0.00							
140	QC3- Inspect Part Finish	0.00							
QC						49x	ϕ	MA	11/07/06
Quality Control	**Memo**	0.00							
150	Identify as per dwg & Stock Location: 27	0.00							
Packaging						11/7/8		(49x)	
Packaging	**Memo**	0.00							

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	**Memo**	0.00							

11/7/11

CME 11-07-08

Picklist Print

Wednesday, June 15, 2011 9:08:54 AM

Work Order ID: 70772

Parent Item: D2934

Parent Item Name: Saddle Spacer

Start Date: 6/15/2011 **Required Date:** 6/22/2011

Start Qty: 40.00 **Required Qty:** 40.00

Comments: IPP A□00.06.06□New Issue□EC□
IPP Rev:B Now 6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			100	sf	256.5000	0.0318	1.338947	1.6 1B11-6-29		

Location	Loc Qty	Loc Code
MAT021	256.5	
116268	33.5	
117285	223	

117285

49

DART AEROSPACE LTD	Work Order:	70722
Description: Saddle Spacer	Part Number:	D2934
Inspection Dwg: D2934 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.475	+/-0.010	.474	✓		V B02	
0.407	+/-0.010	.405	✓		V	
0.250	+0.030/-0.000	.266	✓		V	
R0.30	+/-0.030	.30	✓		R.G.	
Ø0.257	+0.005/-0.000	.260	✓		V	
0.784	+/-0.010	.783	✓		V	
0.826	+/-0.010	.824	✓		V	
R0.36	+/-0.030	.36	✓		R.G.	
0.080	+/-0.010	.077	✓		V	

Measured by:	[illegible]	Audited by:	[illegible]	Prototype Approval:	N/A
Date:	11-6-29	Date:	11/04/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	06.06.23	Dwg Rev. changed	KJ/JLM	
C	08.08.27	0.080 dimension added	KJ/DD	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

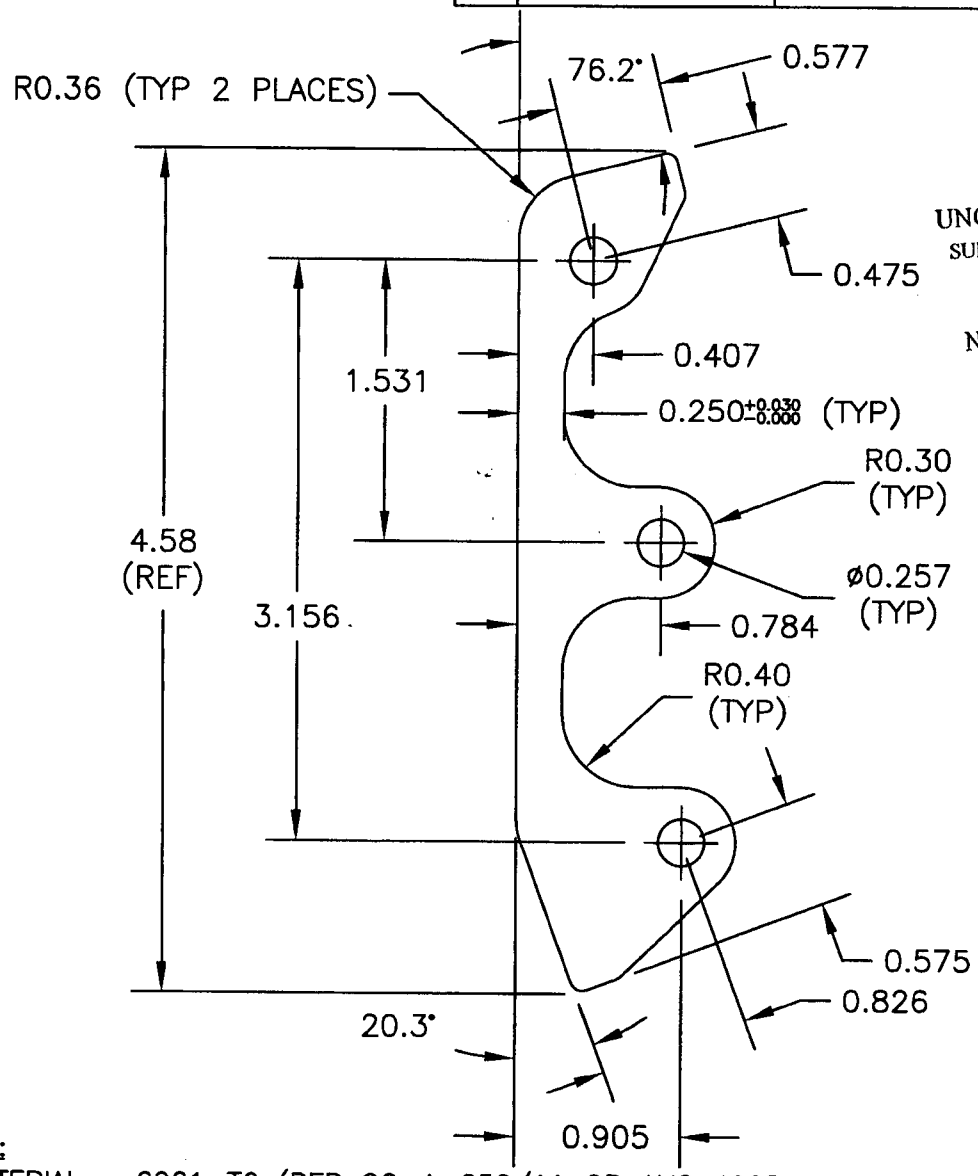
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED	DRAWING NO. D2934	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1

A	99.11.02	NEW ISSUE
B	06.05.29	ADD 6061–T6 MATERIAL



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70222

RELEASED
06.06.20

NOTES:

1) MATERIAL: 6061–T6 (PER QQ–A–250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052–H32/H34 (PER QQ–A–250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK ALL SHARP EDGES 0.010 TO 0.020
5) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries